

## SUPERCINOD 1600

Specially designed low heat input all positional “Low-Temp” electrode for ductile and crack resistant repair welding on grey and nodular cast iron and joining all types of malleable cast iron. The electrode has excellent welding properties and produces smooth bead without transverse undercuts.

### Applications:

Recommended for the repair of machine tools and frames, exhaust manifolds, for oil and bearing casting, cast iron structures and piping connections. Can also be used for joining mild steel and cast iron.

### Procedure:

Gouge out / grind out cracks to “U” shape. Thoroughly clean weld area, remove all oil and grease. Preheating is not necessary but heavy and complex sections should be preheated to 100<sup>0</sup> – 200<sup>0</sup> C. Ensure electrodes are dry. Employ lowest possible current, short arc, stringer beads of length of 20 – 30mm and stagger welding sequence. Remove slag and peen weld deposit between passes.

<u>Technical Data</u>	:	<b>SUPERCINOD 1600</b>			
Size (mm)	:	2.5	3.15	4.0	5.0
Recommended Welding Current (Amps)	:	50-80	80-120	100-140	120-170
Tensile Strength	:	48 kgf / mm <sup>2</sup>			
Yield Strength	:	35 kgf / mm <sup>2</sup>			
Elongation	:	16% approx.			
Hardness	:	188 BHN approx.			
Coating Colour	:	Black			
Tip Colour	:	Pale Cream			

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